

Work Order ID 58989

Thursday, May 20, 2010 3:01:19 PM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 5/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-5-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3912

A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SAD 10-05-21

①

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

SAD 10-05-21

①

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SAD 10-05-21

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/21

MF
10-521

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 20, 2010 3:01:18 PM

Page 1

Work Order ID: 58989

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC

Start Date: 5/20/2010

Required Date: 5/20/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS21209C6-10

Purchased

No

Each

59.0000

1



Heli Coil, screw locking, red



SAD 10-05-21

Location

Loc Qty

Loc Code

ST304

19

108847

16

113705

3

ST305

40

114310

40

D3912-3

Manufactured

No

100

Each

2.0000

2



Eyebolt Block



SAD 10-05-21

Location

Loc Qty

Loc Code

ST096

2

58094

2

D3912-5

Manufactured

No

100

Each

6.0000

2



Eyebolt Plate



SAD 10-05-21

Location

Loc Qty

Loc Code

ST096

6

58095

6

D3912-1

Manufactured

No

100

Each

1.0000

1



Eyebolt



SAD 10-05-21

Location

Loc Qty

Loc Code

FG095

1

58411

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 5/20/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS20615-4M20

Purchased

No

100

Each

164.0000

8



SAD 10-05-21

RIVET

Location

Loc Qty

Loc Code

ST323

164

113254

16

114324

4

114349

144

8

D3810-1

Manufactured

No

Each

31.0000

1



SAD 10-05-21

Hand Retractable Spring Plunger

Location

Loc Qty

Loc Code

ST090

31

54523

1

57319

30

1

D4028-041

Manufactured

No

Each

0.0000

1



SAD 10-05-21

Spring Pin Lanyard Assembly

B53988

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

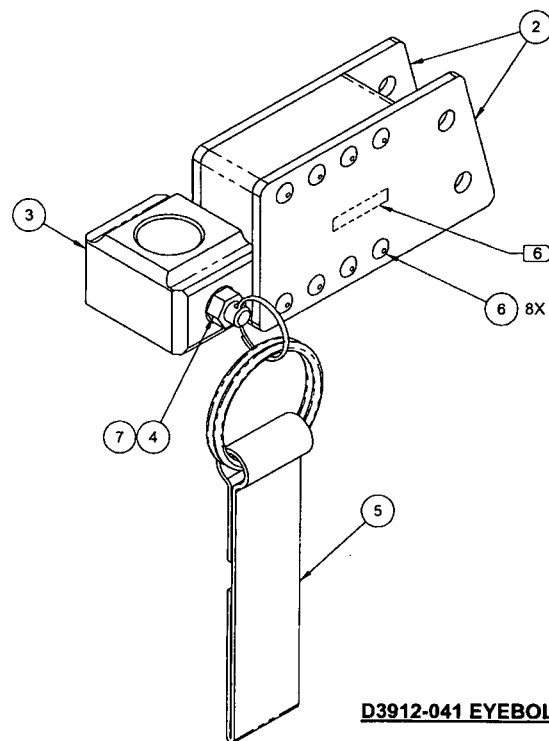
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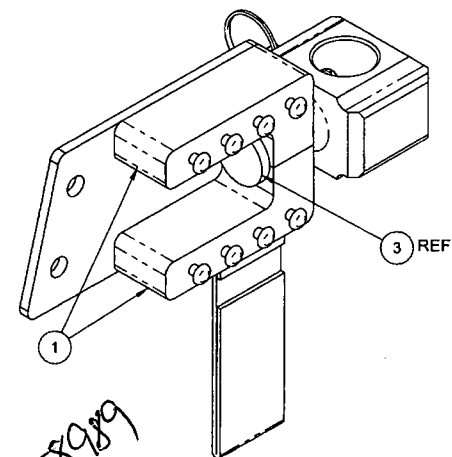
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	2	D3912-3	EYEBOLT BLOCK
2	2	D3912-5	EYEBOLT PLATE
3	1	D3912-1	EYEBOLT
4	1	D3810-1	SPRING PLUNGER
5	1	D4028-041	SPRING PIN LANYARD ASSY
6	8	MS20615-4M20	RIVET
7	1	MS21209-C610	HELICAL (RED LOCKING)



D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.68 lbs



**SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)**

RELEASED
2010-03-12
MP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	GP		
MFG. APPR.	MB		
APPROVED	MB		
DE APPR.	MB		
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. A
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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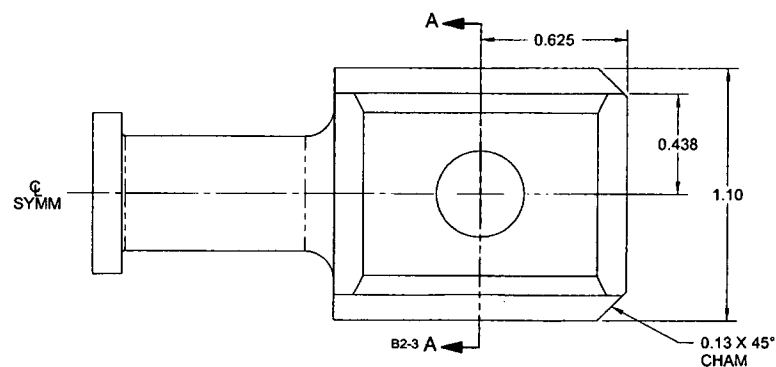
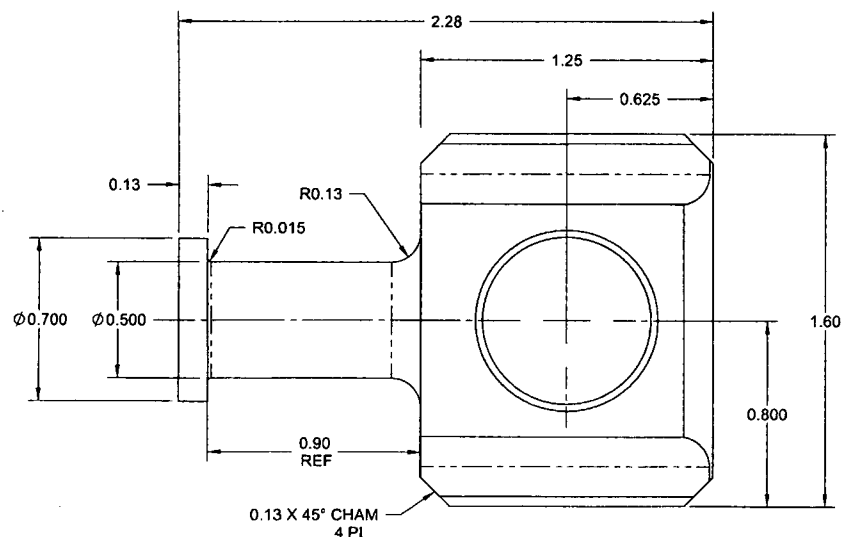
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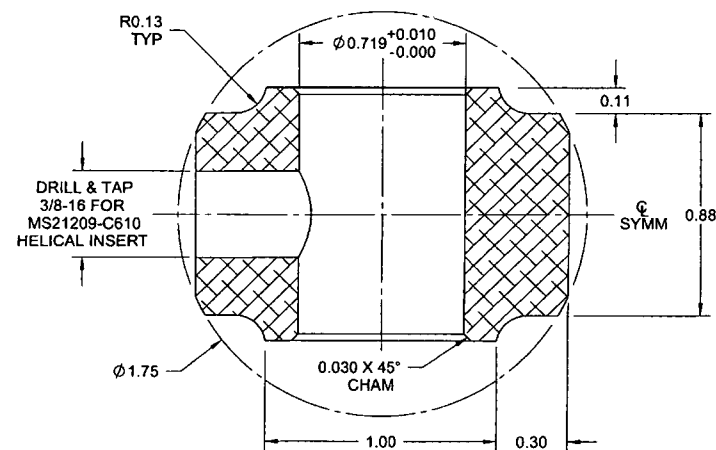
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.49 lbs



SECTION A-A B6-3

RELEASED
2010-03-12
JWP

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3912	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	EYEBOLT RECEIVER ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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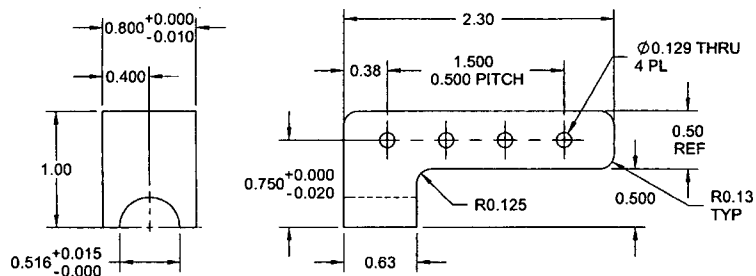
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

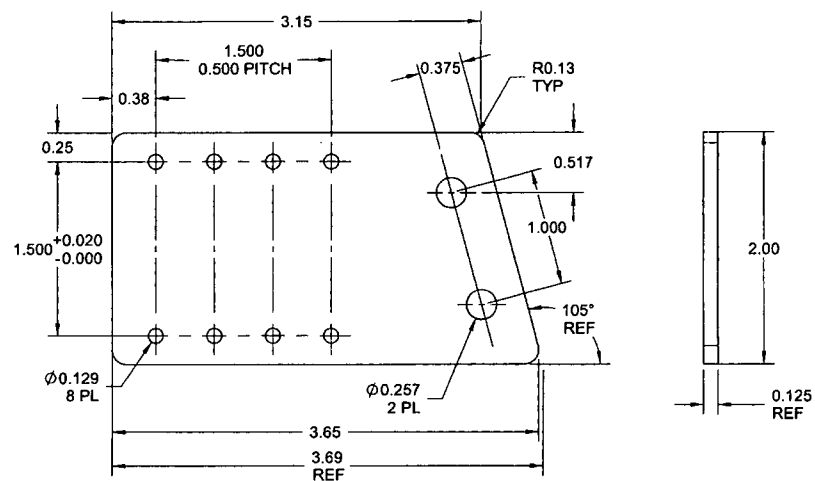
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-03-12
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JPH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JPH</i>	D3912	SHEET 3 OF 3
APPROVED	<i>AW</i>	TITLE	SCALE
DE APPR.	<i>JPH</i>	EYEBOLT RECEIVER ASSY	NTS
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